



Dart Aerospace Ltd.
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Canada

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D2564**Job Sheet 191174**

Part No: D2564

Job Qty: 40 pcs

Part Name: Mounting Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/22/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B1 IPP: D 02.09.09 Re-format; Added FA276 Folio KJ/RF

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	3/18/19	3/18/19	0.00	0.00	Bandsaw - 1		marc 19/03/23
110	HAAS 4 Axis - B4B	10 pcs	3/18/19	3/18/19	0.00	0.00	HAAS - 1 - B4B		marc 19/03/24
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	10 pcs	3/18/19	3/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 47		
140	Packaging 3-1 - Stock - B4B	10 pcs	3/18/19	3/18/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S165433



Part: D2564

Job No: 191174

Serial No/Batch: S165433

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/23/19

QC 8 - 1 (A) K.S.

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	MAZ
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAG
150 QC 21 - SA	10 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	DAG
				QC 21 - SA - 53	

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Part Op **100** - (Bandsaw)Cut D6207 Extrusion: 1.00" Long
 Descriptions: **110** - (HAAS CNC vertical machine #1)1- Mill as per Folio FA276 Rev: _____ & Dwg D2564 Rev: _____
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____) *** STOCK IN STEP CELL ***
150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6A1.000W.125	6061T6 Angle 1.00 X 1.00 X .125W	.9160 ft (.0916 ea)	100-Bandsaw - 1	M 137515

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6A1.000W.125	1	19	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Angle	1.000inches $\pm$ 0.030	1.030 0.970	1.005	
2	Mounting Angle	0.625inches $\pm$ 0.010	0.635 0.615	.620	
3	Mounting Angle	0.257inches $\pm$ 0.010	0.267 0.247	.260	
4	Mounting Angle	1.000inches $\pm$ 0.010	1.010 0.990	1.00	
5	Mounting Angle	1.000inches $\pm$ 0.010	1.010 0.990	1.00	
6	Mounting Angle	0.375inches $\pm$ 0.010	0.385 0.365	.375	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					